

Work Order ID 60571 - 2

Wednesday, July 14, 2010 9:20:18 AM

Page 1

Item ID: D3393-041

Accept

Setup Start

Revision ID:

Item Name: Battery Lock Assembly

Stop

Start Date: 7/14/2010 Start Qty: 5.00

Required Date: 7/22/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-14 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5 3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

SB 10/11/08

7

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long Qty Part Number Description Batch A/RN/A SS Rod 111585

7x 10.10.08

120

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE 12.11.09 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

Small Fab

Apply Crazy Glue to cap and press into Body □9567K21
Batch: Y115663

SB 10/11/11

(7)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/11

(7)

150



Packaging

Packaging

Identify as per dwg & Stock Location: 487

0.00

Memo

0.00

8/10/11 (7)

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Required Date: 7/22/2010 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/11
10-11-11
7

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Wednesday, July 14, 2010 9:20:22 AM

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Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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Abstract

M1, Loc Code
5824

500

69

ST052

33

Sp 10/11/11 ⑦

~~SB 10/11/11 (7)~~

SD 10/11/11 (7)

SB 10/11/11 (7)

10 SB 10/11/11 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:20:22 AM

Page 2

Work Order ID: 60571

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 5.00

Required Qty: 5.00

D3393-1 Manufactured No

100 Each 0.0000

1

5



B 59773



(10)

SB 101111

②

Battery Lock Casing

D3393-3 Manufactured No

140 Each 7.0000

1

5



SB 101111

②

Cam Lock Shaft

Location

Loc Qty

Loc Code

ST055

7

48630

7

61947

7
3

Wednesday, July 14, 2010 9:20:22 AM

Shop Packet Print

Page 2

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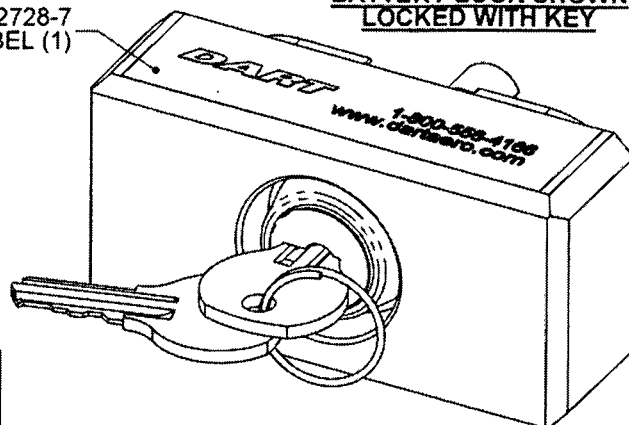
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

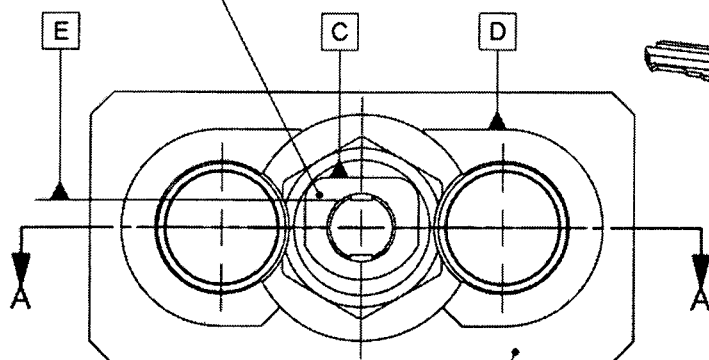
05/03/09

D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) ²/₂
AND APPLY KRAZY GLUE

0.09^{+0.03}_{-0.01} (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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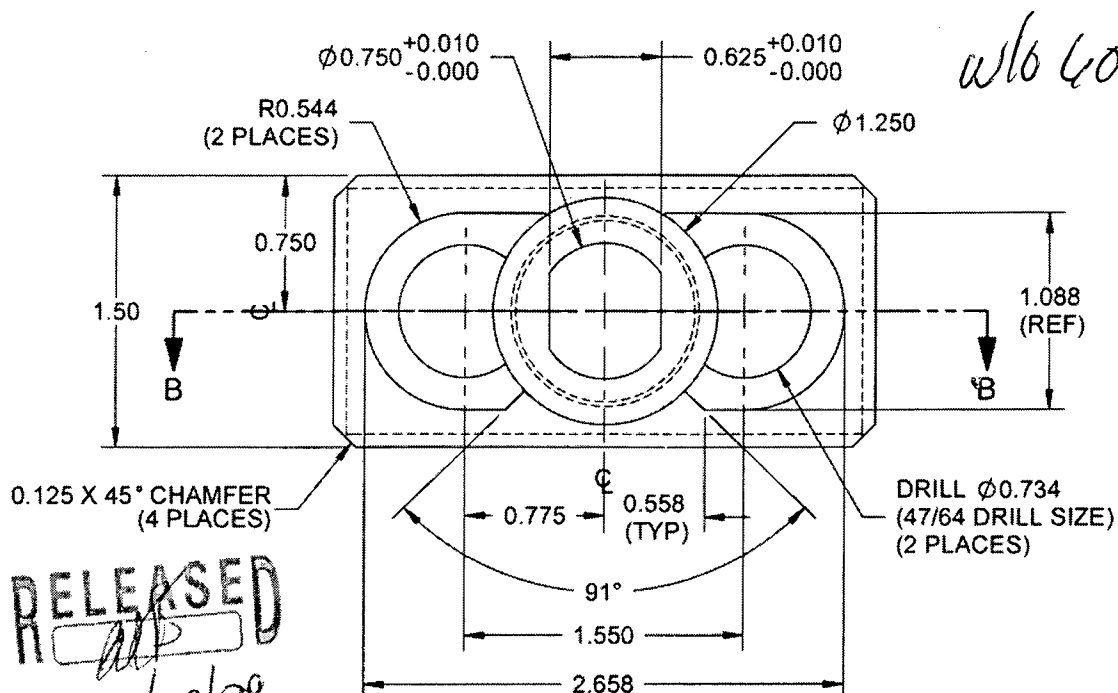
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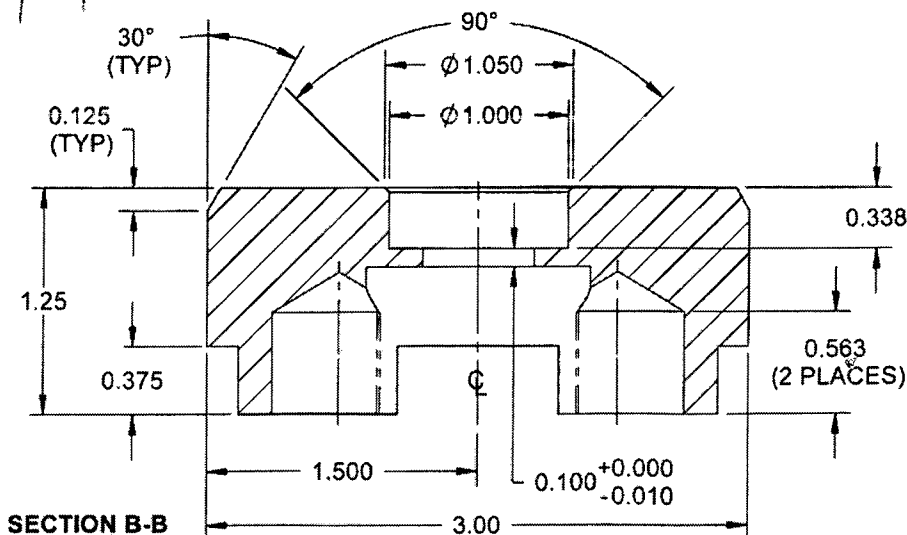
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1



RELEASED
[Signature]
05/03/09

**D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

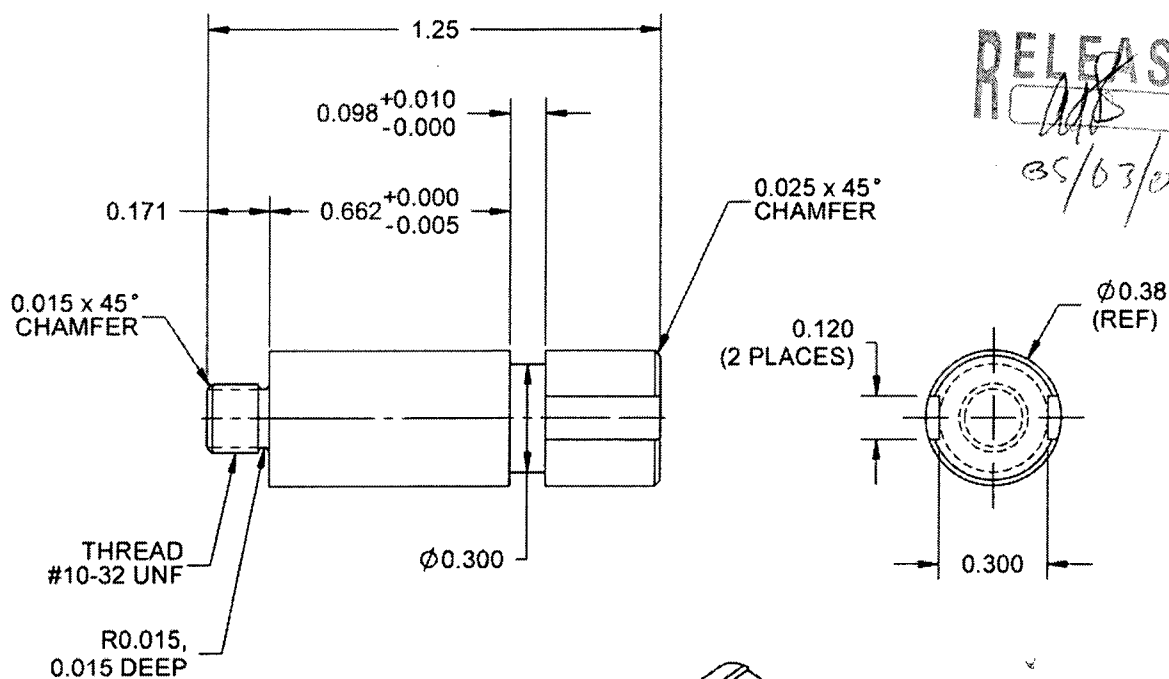
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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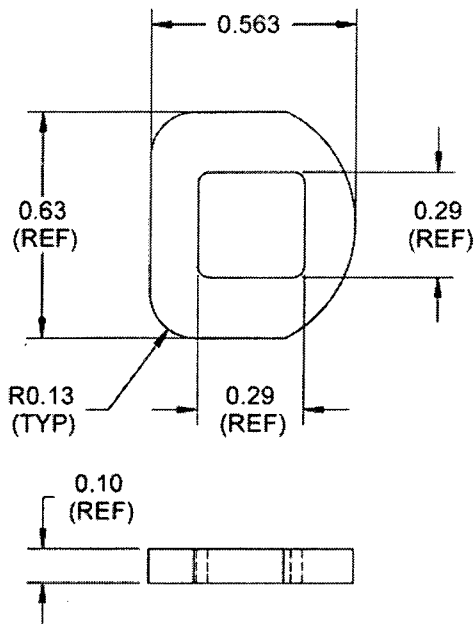
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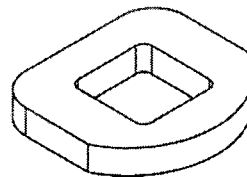
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING

**RELEASED**
[Signature]

05/02/11

**REFERENCE ONLY**

-5
D3369 SPACER

**NOTES:**

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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